

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 10827 (1984): Roving Punches [PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

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“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



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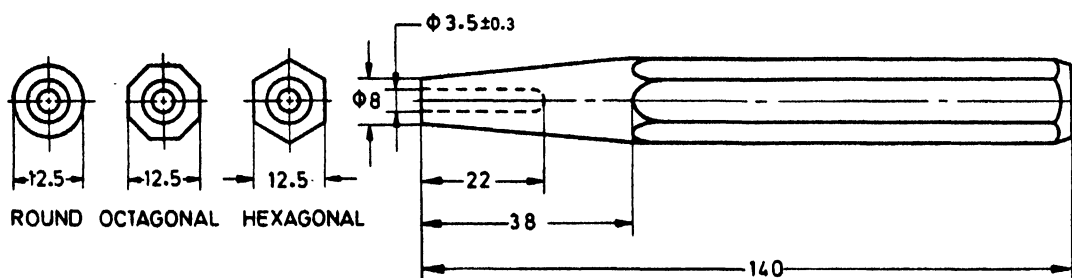
## Indian Standard

### SPECIFICATION FOR ROVING PUNCHES

**1. Scope** — Covers the requirements of roving punches, used by bootmakers to mount roves on copper boot nails and rivets of 3 mm size.

#### 2. Dimensions

**2.1** Dimensions of roving punches shall be as shown in Fig. 1.



All dimensions in millimetres.

FIG. 1 DIMENSIONS FOR ROVING PUNCHES

**2.2** Tolerances on dimensions shall be according to coarse class specified in IS : 2102 (Part 1)-1980 'General tolerances for dimensions and form and position: Part 1 General tolerance for linear and angular dimensions (second revision)'.

**3. Material** — Shall be manufactured from carbon steel conforming to designation T-70 of Schedule VI of IS : 1570-1961 'Schedules for wrought steels for general engineering purposes' with maximum phosphorus and sulphur contents as 0.05 percent each.

#### 4. Manufacture, Workmanship and Finish

**4.1** The punches shall be made of either hexagonal, octagonal or round cross section. The round punches shall have knurled surface for easy grip.

**4.2** The punches shall be soundly forged, neatly machined and free from cracks, seams, burrs, scales and other surface defects.

**4.3** The punches shall be finished smooth all over, with the tapered portion finished bright. The working ends shall be properly hardened and suitably tempered.

**5. Hardness** — 450 — 550 HV ( $\approx$  40 — 50 HRC).

#### 6. Test

**6.1 Performance Test** — The punch, with working end downward, shall be placed on an anvil interposing a mild steel plate of 6 mm thickness. Four full blows shall be struck on the shank end with 1-kg steel hammer. The punch shall show no sign of damage or distortion on either ends on completion of the test.

#### 7. Marking

**7.1** Each punch shall be clearly marked/stamped with manufacturer's name or recognised trade mark and year of manufacture.

**7.2 ISI Certification Marking** — Details available with the Indian Standards Institution.

**8. Packaging** — Preservation, packaging and marking on the packages shall be as prevalent in the trade practice or as agreed between the manufacturer and the purchaser.

Adopted 19 January 1984

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## **9. Sampling**

**9.1** In order to ascertain the conformity of lot, the procedure for sampling inspection as given in IS : 2500 ( Part 1 )-1973 ' Sampling inspection tables: Part 1 Inspection by attributes and count of defects ( *first revision* ) ' shall be followed. The inspection level and AQL for various characteristics shall be according to **9.2** and **9.3**.

**9.2** For dimensions as well as workmanship and finish, single sampling plan with inspection level IV and AQL of 4 percent given in Table 1 and 2 of IS : 2500 ( Part 1 )-1973, shall be followed.

**9.3** For hardness and performance tests, a single sampling plan with inspection level IV and AQL of 1.5 percent as given in Table 1 and 2 of IS : 2500 ( Part 1 )-1973 shall be followed.

## **EXPLANATORY NOTE**

While preparing this specification, considerable assistance has been derived from the Joint Services Specification JSS 5120-29, Roving Punches, issued by Ministry of Defence, Government of India.

**AMENDMENT NO. 1 MAY 1996  
TO  
IS 10827 : 1984 SPECIFICATION FOR  
ROVING PUNCHES**

( *Page 1, clause 2.2, line 1* ) — Substitute 'IS 2102 ( Part 1 ) : 1993 General tolerances : Part 1 Tolerances for linear and angular dimensions without individual tolerance indications ( *third revision* )' for 'IS : 2102 ( Part 1 ) - 1980 General tolerances for dimensions and form and position : Part 1 General tolerance for linear and angular dimensions ( *second revision* )'.

( *Page 2, clause 9.1, line 2* ) — Substitute 'IS 2500 ( Part 1 ) : 1992 Sampling inspection procedures : Part 1 Attribute sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection ( *second revision* )' for 'IS : 2500 ( Part 1 ) - 1973 Sampling inspection tables: Part 1 Inspection by attributes and by count of defects ( *first revision* )'.

( *Page 2, clauses 9.2 and 9.3, line 2* ) — Substitute 'Tables I and II-A of IS 2500 ( Part 1 ) : 1992' for 'Tables 1 and 2 of IS : 2500 ( Part 1 ) - 1973'.

( PE 06 )

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